

Date: Wednesday, 5/23/2007 4:01:46 PM
 User: Kim Johnston

Process Sheet

25

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
 Job Number : 32528
 Estimate Number : 10266
 P.O. Number : N/A Part Number : D350636013
 This Issue : 5/23/2007 S.O. No. : N/A Drawing Number : D2750 UNDER REVIEW 07.05.24
 Prsht Rev. : NC Project Number : N/A CB
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D
 Previous Run : 32527 Material : N/A
 Due Date : 6/20/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07.05.24
 Comment : Est Rev.H 02.09.25 Rearranged procedure steps KJ
 est rev I 06.03.30 Per rev. D dwg EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 002

KS 07.06.04

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B30666

7-6-4

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

229784

BE

07-06-07

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

7-6-4

7-6-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 4:01:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Drill pilot holes for Detail B using DT8330

5-Open float holes to .375"

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube*****

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

8- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

9-Countersink Detail A as per dwg D2750.

10-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod M102421 BE 07-06-07

12-Grind welds flush as per Dwg D2750

pm 07-06-07 @

5.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/07

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-6-07

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

pm 07-06-07 @

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-6-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

(welding instructions on sheet 5)

A/R Aluminum Rod batch: ~~M10242~~ M104305 BE 07-06-20

7-Grind welds flush as per Dwg D2750 *for 07-06-20*

8-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 *for 07-06-20*

9-Deburr holes *for 07-06-20*

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/21

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M104305

16.0

POWDER COATING

POWDER COATING

PRESSURE WASH 07-08-01 BR.



Comment: POWDER COATING

M105068

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

BR

07-08-01

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

35 07-08-02

18.0

NAS1330S3KB166

INSERT



NAS1330C3KB166



(P70) ->

Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

INSERT

Batch: *103279* * *35* *07-08-02*

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

35 07-08-02



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC5

INSPECT WORK TO CURRENT STEP



P10

Comment: INSPECT INSERTS

En 07/08/02 (4)

21.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Wearpad

Batch: B 31695

SH

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B 30553

SH

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B 30554

SH

24.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B 30141

SH

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

Batch: M 31697

SH

26.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, LH

Batch: B 29432


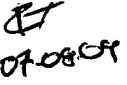

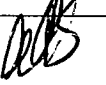

SH

07-08-03 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/08/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-09	18-0 ↓ 20-0	Employee used the incorrect inserts: NAS1330C3KB166 instead of NAS1330S3KB166 R.C.: Human error, part # was not fully checked.		Inserts acceptable this time only. Inform employee's of deviation, and check the part # before using. See W/O's B32530 & B32529	 07-08-09 En 07/08/09	 07-08-09		 07-08-09

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 4:01:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 13 32598 *

MS

28.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 13 32599 *

MS

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M 104118

MS

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M 103693

MS

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M 103668

MS

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M 103964

MS

33.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M 102671

MS 07-08-03 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)
washer

Batch: M105057

JS

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER

Batch: M104093

JS

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
NUT

Batch: M103093

JS

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
NUT

Batch: M103492

JS

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)
WASHER

Batch: M104603

JS

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
WASHER

Batch: M104922

JS

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside of tube with "LPS-3" batch: M105085
Inspect for foreign objects as Dart QSI 024

M105085

JS

04-08-030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M1104989

EXP DATE: 08-01

3-Coat all exposed fasteners with "LPS Procyon" batch: M1104251 04-08-03 0

41.0

QC5

INSPECT WORK TO CURRENT STEP



All plugs are installed



Comment: INSPECT WORK TO CURRENT STEP

Sn 02/0867 (1)

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Gr Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 6305567

44.0

AN960C816L

WASHER



Gr Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M104093

45.0

MS21083C8

NUT



Gr Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M104118

46.0

AN8C21A

BOLT



Gr Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104117

Gr 04/08/07 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/01/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 5/23/2007 4:01:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32528

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M104955

48.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B32600

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C7/08/09

B32528

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
06.02.07 *AK***UNDER REVIEW** *OK*
*CB*07.02.05 *CB**add gaskets
change to SS wearplates*

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>AK</i>	APPROVED <i>AK</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32528

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

UNDER REVIEW

07.02.05 CB

SS wearplates

OK
CB

RELEASED
06.02.07

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\emptyset 0.250$ - $\emptyset 0.257$) FOR WEARSHOE INSERTS. C'SINK $\emptyset 0.391 \times 100^\circ$ AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 32528

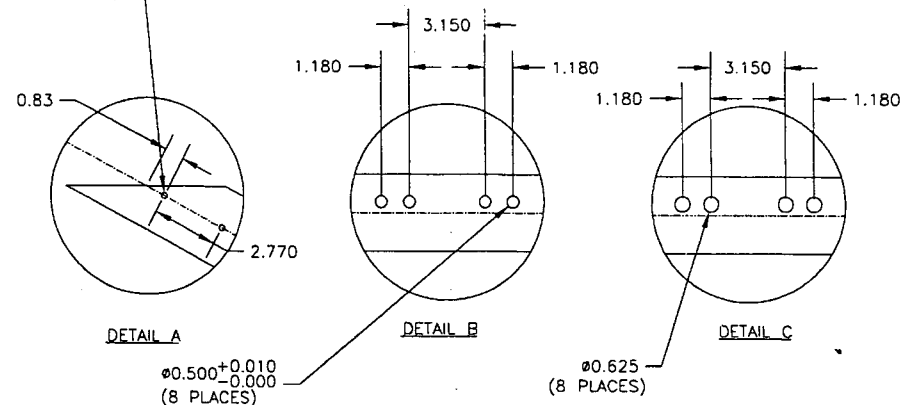
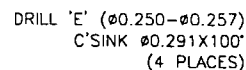
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ok
CB

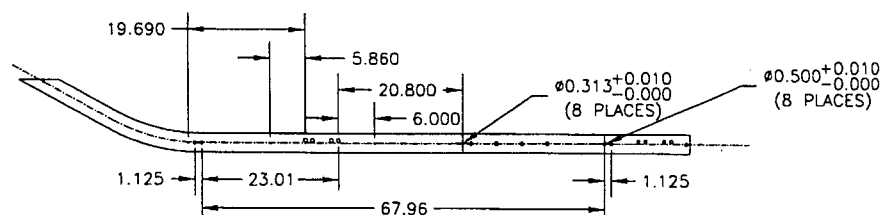
~~SS war-plates~~

RELEASED
05-02-07

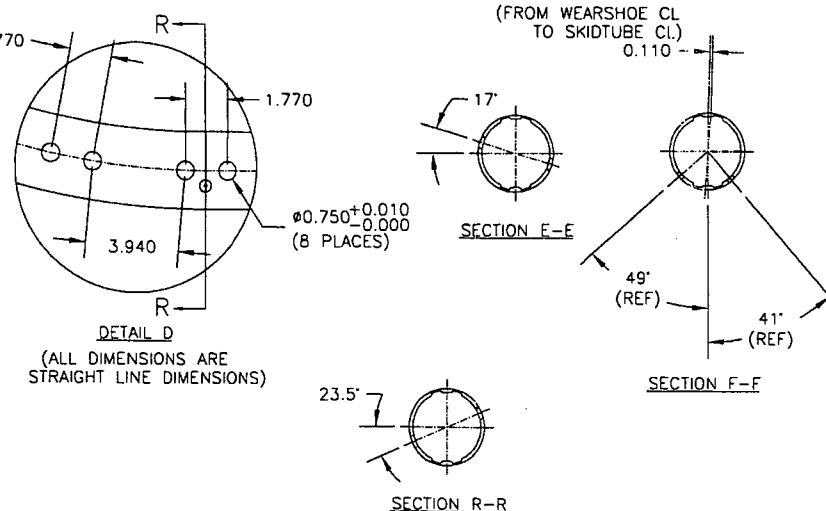


D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)

- DRILL 'E' (Ø0.250-Ø0.257) WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1
PER SECTION F-F (42 PLACES). 1.770
USE DT8108-2 FOR DT250-2.
C'SINK Ø0.391x100° WEARSHOE HOLES
(38 PLACES)
DO NOT C'SINK D3488-041/-042 HOLES



D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)
D2750-3/-4 AND D2750-1/-2 HAVE THE SAME SADDLE AND
GROUND HANDLING HOLES



DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV.
3 OF 3

SCAL

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WITHOUT NOTICE
WORK ORDER
NO. 38528

UNDER REVIEW

07.07.05 CB
OK CB

D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)

INSTALL NAS1330S3KB166
INSERTS (4 PLACES)
AFTER FINISH

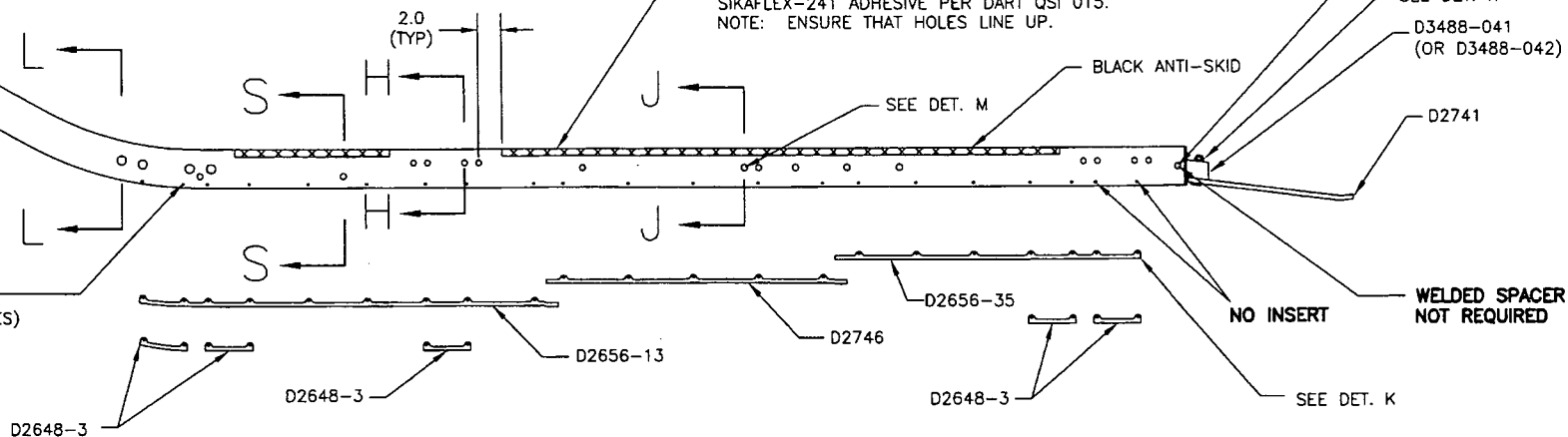
BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

SEE DET. Q

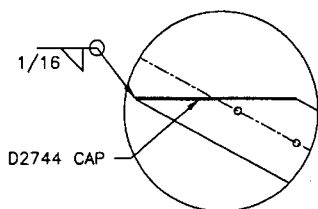
DETAIL G

INSTALL NAS1330S3KB166
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

RELEASED
06.02.07 #



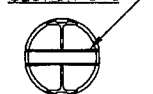
DETAIL G



SECTION H-H



SECTION J-J



WELDING INSTRUCTIONS

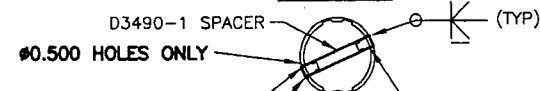
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO $\phi 0.484$
6. SPOT FACE $\phi 0.750$ (SECTION J-J ONLY)

SECTION L-L



D3492-043 PLUG ASSEMBLY

SECTION S-S



D3492-041 PLUG ASSEMBLY

WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO $\phi 0.500$ HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO $\phi 0.750$ HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

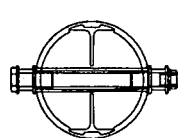
DETAIL K



USE AN3C7A BOLTS
FOR INSTALLING AFT
D2648-3 WEARPAD
(4 PLACES)

AN3C5A BOLT (1)
AN960JD10L WASHER (1)
NAS1515H3L WASHER (1)
(38 PLACES)

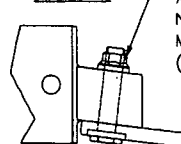
DETAIL M



AN6-44A BOLT (1)
D2745 BUSHING (2)
NAS1515H8L WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)

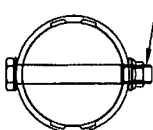
NOTE: INSTALL WASHER BETWEEN
SKIDTUBE AND BUSHING

DETAIL N



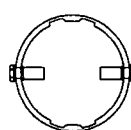
AN8C21A BOLT (1)
AN960JD816L WASHER (1)
NAS1515H8L WASHER (1)
MS21083C8 NUT (1)
(2 PLACES)

DETAIL P



AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

DETAIL Q



AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

NO. 38528
WORK ORDER
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DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	
CHECKED	APPROVED	DRAWING NO.	REV. 0
		D2750	SHEET 4 OF 5
DATE		TITLE	SCALE
06.01.05		350 SKIDTUBE ASSEMBLY	1:20

UNDER REVIEW

01.07.05 CB

ok CB

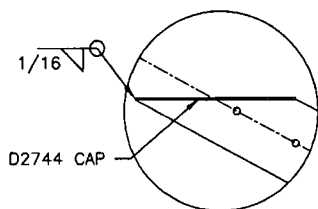
SEE DET. Q

DETAIL G

INSTALL NAS1330S3KB166
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

RELEASED
06.02.07.14

DETAIL G



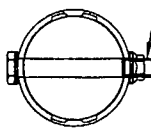
DETAIL K



USE AN3C7A BOLTS
FOR INSTALLING AFT
D2648-3 WEARPAD
(4 PLACES)

AN3C5A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(38 PLACES)

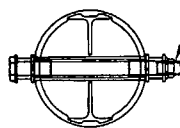
DETAIL P



AN8C35A BOLT (1)
AN960C816L WASHER
NAS1515H8L WASHER
MS21083C8 NUT (1)

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DETAIL M



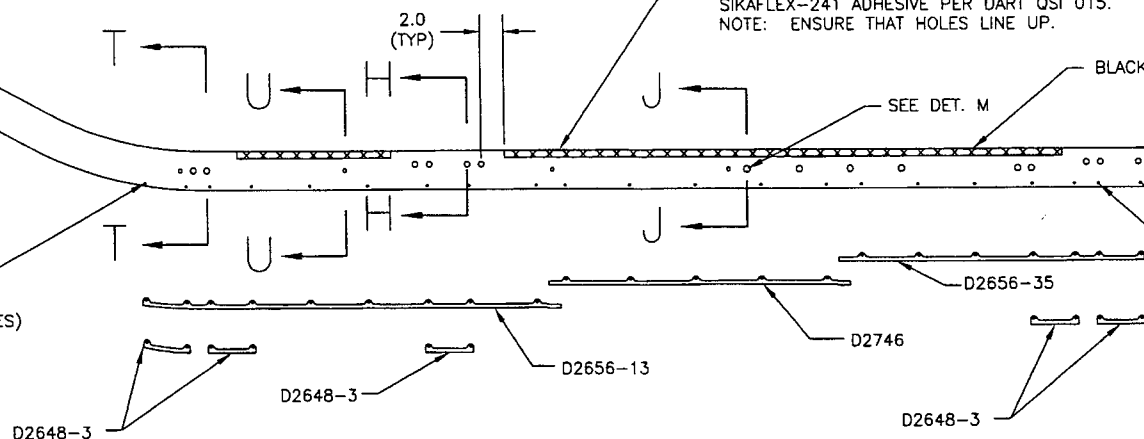
AN6C44A BOLT (1)
D2745 BUSHING (2)
NAS1515H8L WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)
NOTE: INSTALL WASHER BETWEEN
SKIDTUBE AND BUSHING

DETAIL Q



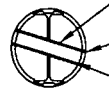
AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)



BOND D2739 WEB INTO D2750-3 (OR D2750-4)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

SECTION H-H



D2743 SPACER (REF)

(TYP)

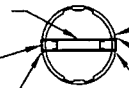
SECTION J-J



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

SECTION T-T

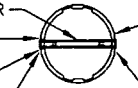


D3490-1 SPACER

Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

SECTION U-U



D3490-5 SPACER

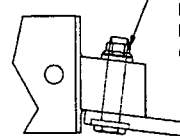
Ø0.313 HOLES ONLY

D3492-045 PLUG ASSEMBLY

WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

DETAIL N



AN8C21A BOLT (1)
AN960JD816L WASHER (1)
NAS1515H8L WASHER (1)
MS21083C8 NUT (1)
(2 PLACES)

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DESIGN	DH	DRAWN BY	DH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D2750
DATE	06.01.05	TITLE	350 SKIDTUBE ASSEMBLY	REV. 0 SHEET 5 OF 5 SCALE 1:20

NO. 113

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 380636014 / A32531

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into N/A Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/06/19 Qualifier David A. Avel

Initiator: Jason Kerr
 Company: GCTPA (HANGAR LLC)
 Phone No. 262-798-5080
 Reason for return: Customer wanted the SS wearplates
PAR 02-000

Date: April 27/08Invoice # 6364Order Entry # 5904Attach Copy of DHS Return Authorization # 404

REFERENCE ONLY

Receiving:

Date Received: 8/5/10 Freight Company: MINIMA Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
1	D350-636-013	32528	Skid tube LH	Advise QA	Date:
1	D350-636-014	31681	Skid tube RH	<u>DAVE</u>	<u>8/5/10</u>

Condition of packaging: GOOD Photograph required: yes ☒ noPaperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC:

Quarantine: Location: Condition of Part: goodInspect: Initial:

#	Part #	Batch #	QC Comments	QC Approval		Scrap
1	D350-636-013	632528	re-worked per spec / OSI 9/13 Rev A.	Initial	W/O #	
1	D350-636-014	B31681		<u> </u>	<u>39347</u>	
					<u>39349</u>	

QA Coordinator:

Advise GM as to findings: Initial: Date: Comments:

*NO charge
already sent*

Issue credit: yes ☒ noGM Approval: Date: Invoice Amount: Less Replacement: Restock Fee: Freight: Net Credit: DHS ☐ Customer ☐QA: Enter into Q-Pulse with reason for return & File original. Signed: Date:

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit